

Date: Monday, 1/14/2008 2:37:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOUBLER		
Job Number	36756					
Estimate Number	12108					
P.O. Number				Part Number	D32013	
This Issue	1/14/2008	S.O. No.	:	Drawing Number	D3201 REV B	
Prsh Rev.	NC			Project Number	N/A	
First Issue	/ /	Type	SMALL /MED FAB	Drawing Revision	B	
Previous Run	32474			Material		
Written By	<u>KJ 08/01/15</u>			Due Date	2/5/2008	Qty: 40 Um: Each
Checked & Approved By						
Comment	Est Rev: A	Removed from 9 Digit	06-01-25	JLM		
	Est Rev:B	Now on Waterjet	06-08-14	JLM		
	Est Rev C	added scribing NCR262	07.11.29	EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
		2.2	
		Comment: Qty.: 0.0473 sf(s)/Unit Total : 1.8900 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Batch: <u>10S64L</u> HB 8-1-16	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3201 Dwg Rev: <u>B</u> HB 8-1-16 Prog Rev: <u>B</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 8-1-16	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack	
		<u>u</u>   <u>v</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 36756

Part Number: D32013

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Bend as per Dwg D3201

SB 08/01/18  
④

*Scrub part# and Batch# per dwg D3201*

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*(In color, b)*

*(X46)*

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*white paint*

08-01-21 (X46)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F& 08/01/21 (46)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5776*

*1/8/21* (46)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



08-01-22 (46)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 08/01/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	367560
Description: Doubler	Part Number:	D3201-3/-4
Inspection Dwg: D3201 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>LB</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-1-16	Date:	08/09/17	Date:	N/A

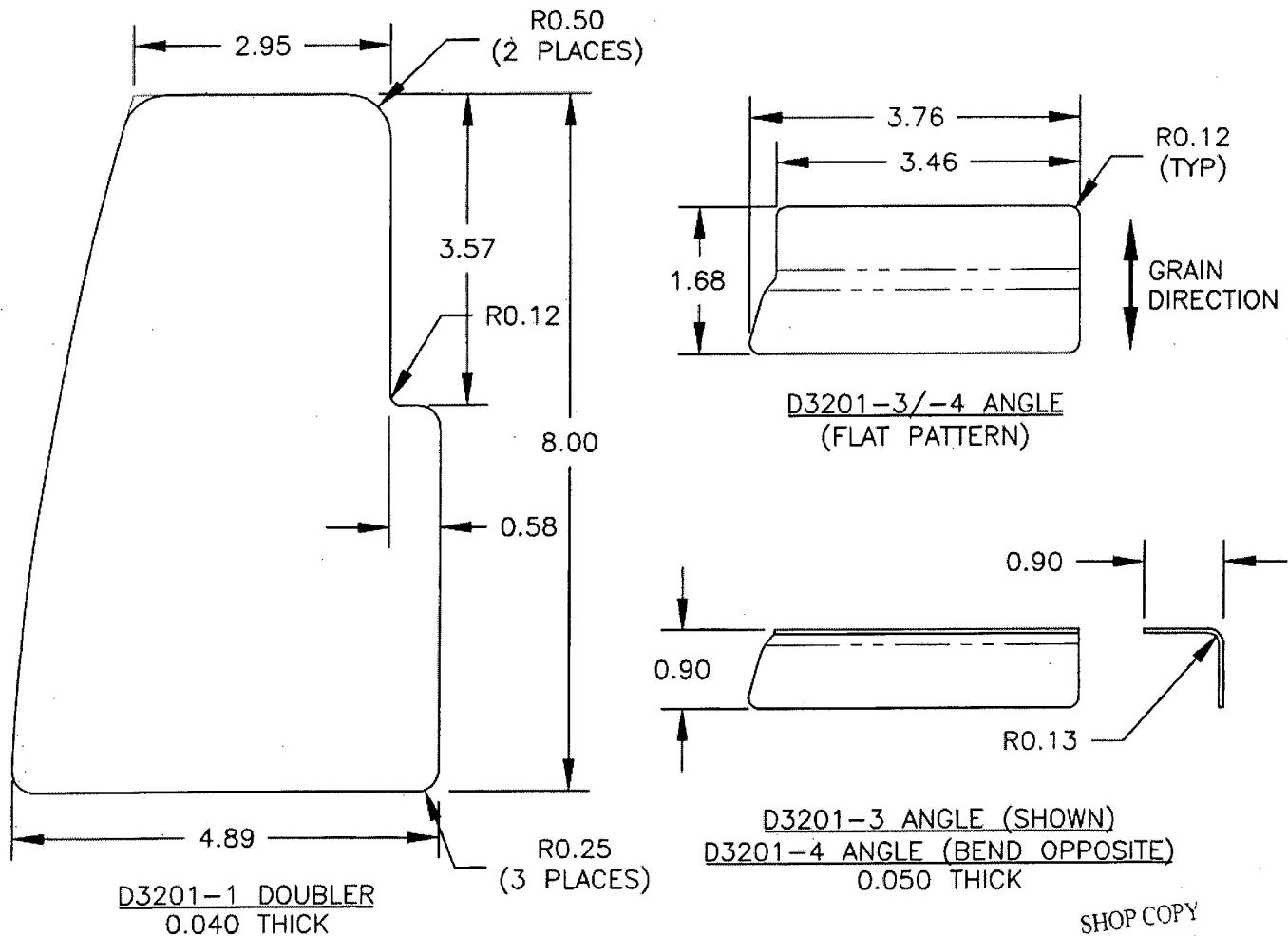
Rev	Date	Change	Revised by	Approved
A	03.11.28	New Issue P/O D412-698-015	KJ/RF	JF

**DART**

DESIGN	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED <i>CP</i>	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE	TITLE DOUBLER		SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

**RELEASED**

03.11.03

**D3201-1/-3/-4 DOUBLER**

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)  
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *36756*